



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5425-043
Job Sheet 170126



Part No: D5425-043

Job Qty: 1 ea

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 1/19/18

Type: Stock

Description:

Note: IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS

Ship Via:

V.O. 18/01/18
U/R

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/16/18	1/16/18	0.00	0.00	Start Up Skidtubes-2		
110	Skidtubes	1 pcs	1/17/18	1/17/18	0.00	8.24	Skidtubes-3		AP 2018-01-11
120	CNC Vertical Machining	1 pcs	1/18/18	1/18/18	0.00	22.77	HAAS1-4		Kt 18-01-19
130	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC2 Machining-4		Kt 18-01-19
140	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC8 Machining-4		2018/01/23
150	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.24	HandFinish1		2018/01/23
160	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC7-5		
170	CNC Bend Skidtubes	1 pcs	1/18/18	1/18/18	0.00	2.63	CNC Bend Skidtube		
180	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		
190	Skidtubes	1 pcs	1/18/18	1/18/18	0.00	8.24	Skidtubes-3		
200	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		
210	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.24	HandFinish6		
220	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC7-5		
230	Skidtubes	1 pcs	1/18/18	1/18/18	0.00	8.24	Skidtubes-3		
240	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		
250	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.24	HandFinish6		
260	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC7-5		
270	SprayPaint	1 pcs	1/18/18	1/18/18	0.00	0.00	Spray Paint		
280	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC14		
290	HandFinish	1 pcs	1/19/18	1/19/18	0.00	0.24	HandFinish4		
300	QC	1 pcs	1/19/18	1/19/18	0.00	0.00	QC5		
310	Packaging	1 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-2		
320	QC21-SA	1 Ea	1/19/18	1/19/18	0.00	0.00	QC21		

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.

Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: _____ FOLIO REV: _____ 2-Deburr as per Dwg.

150 - 1-Scrub inside of tube with medium scotchbright.

170 - 1-Bend Aft end of tube as per Dwg. and Folio _____. Insert Bending mandrel DT 10328 at _____" from aft end. Use buggy A,B,C AND DT _____ A & B. to stabilize tube. HEIGHT _____ 2-Bend Forward end of tube as per Dwg. and Folio _____. Insert Bending mandrel DT 10328 at _____" from fwd end. Use buggy A,B,C AND DT _____ A & B. To stabilize tube. HEIGHT _____ 3-Record dimentions on work order.

180 - #NAME?

190 - 1-Drill remaining holes of section I-I using DT _____ 2-Drill remaining holes of section J-J using

DT _____ 3-Open holes to finished size as per Dwg. 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.

230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B _____ Start

DART
AEROSPACE
S031473



Float Skidtube Assembly

PART NO:
Revision:
Operation:
Change No:

D5425 - 043

Start up Operation

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 01/11/18
Job No: 170126

Time: _____ Finish Time: _____ ***CURE TIME _____ HRS. BEFORE PROCEEDING TO NEXT STEP***

2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1

250 - *DO NOT SUBMERGE TUBE IN DEOXIDIZER*****

270 - *PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT***** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT

BATCH: _____

290 - 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B _____ Exp; _____ Start time: _____

Finish time: _____ 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R LPS Procyon B _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6028-195 017944	1	20	0	0
230-Skidtubes	D5512-1	12	66	0	0
	D5518-1	18	78	0	0
290-HandFinish	AN3C5A	6	1,462	0	0
	D3672-1	6	1,133	0	0
	D5483-041	1	0	0	0
	D5484-041	1	0	0	0
	NAS1149C0332R	6	4,369	0	0

Part Specifications

Specifications could not be found.

Plex 1/10/18 1:32 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

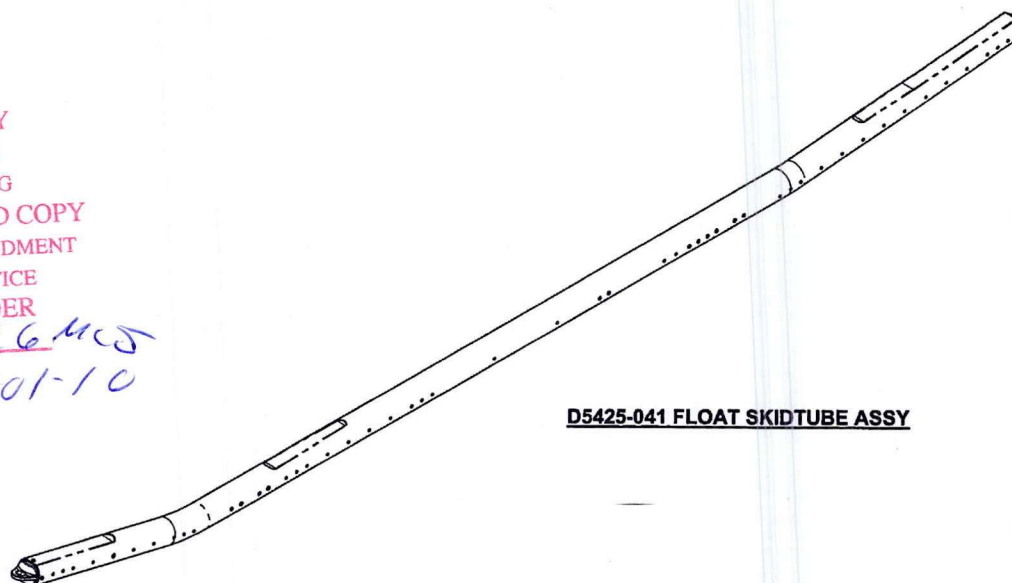
Work Order update only ☐

Work Order: <u>170126</u> Part No. <u>D5425-043</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>18/01/10</u>		Step #: <u>190</u>		QTY Effective: <u>1</u>		MRB (QSI042) Approval DAS 12 9-89 <u>18/1/10</u>																																																																	
Description Work Order Deviation				Disposition																																																																			
- current hole diameters can cause crossbolt spacers to bend in off CL holes				- ream off CL holes to 0.383 ± 0.000 as shown in attached annotated drawing (Detail N and P) - final hole size within original tolerance, no deviation required for QC		Completed By																																																																	
						Lead hand / Supervisor Approval Verification																																																																	
						QC / QA Coordinator Approval																																																																	
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>				Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr><td>Pressure/Forced ☐</td><td>Temperature/Cure ☐</td><td>Power Loss/Surge ☐</td><td>Positioned Wrong ☐</td></tr> <tr><td>Bending ☐</td><td>Set-up ☐</td><td>Folio/Program ☐</td><td>Outside Dimensions ☐</td></tr> <tr><td>Centre Not Concentric ☐</td><td>BOM/Route ☐</td><td>Grain ☐</td><td>Over/Under tolerance ☐</td></tr> <tr><td>Cracks ☐</td><td>Broken/Damage/Defect ☐</td><td>Weld ☐</td><td>Part Incorrect ☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Inspection Incomplete/Unqualified ☐</td><td>Wrong Stock Pulled ☐</td><td>Part Lost/Missing ☐</td></tr> <tr><td>Cuffs ☐</td><td>Contamination ☐</td><td>Out of Sequence ☐</td><td>Part Moved ☐</td></tr> <tr><td>Crushing ☐</td><td>Countersink ☐</td><td>Off-set ☐</td><td>Drawing ☐</td></tr> <tr><td>Heat Treat ☐</td><td>Cut Too Short ☐</td><td>Mislabeled ☐</td><td>Finish ☐</td></tr> <tr><td>Wave/Twist in Tube ☐</td><td>Instructions Incomplete/Unclear ☐</td><td>Fit/Function ☐</td><td>Misread ☐</td></tr> <tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td><td>Misaligned/off center ☐</td><td>Turning Sequence ☐</td></tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER: _____																																																																							

QTY -041	P/N	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN3CSA	BOLT
6	NAS1149C0332R	WASHER

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WITHOUT NOTICE
WORK ORDER

NO. 170126 MJS
1801-10



D5425-041 FLOAT SKIDTUBE ASSY

UNDER REVIEW

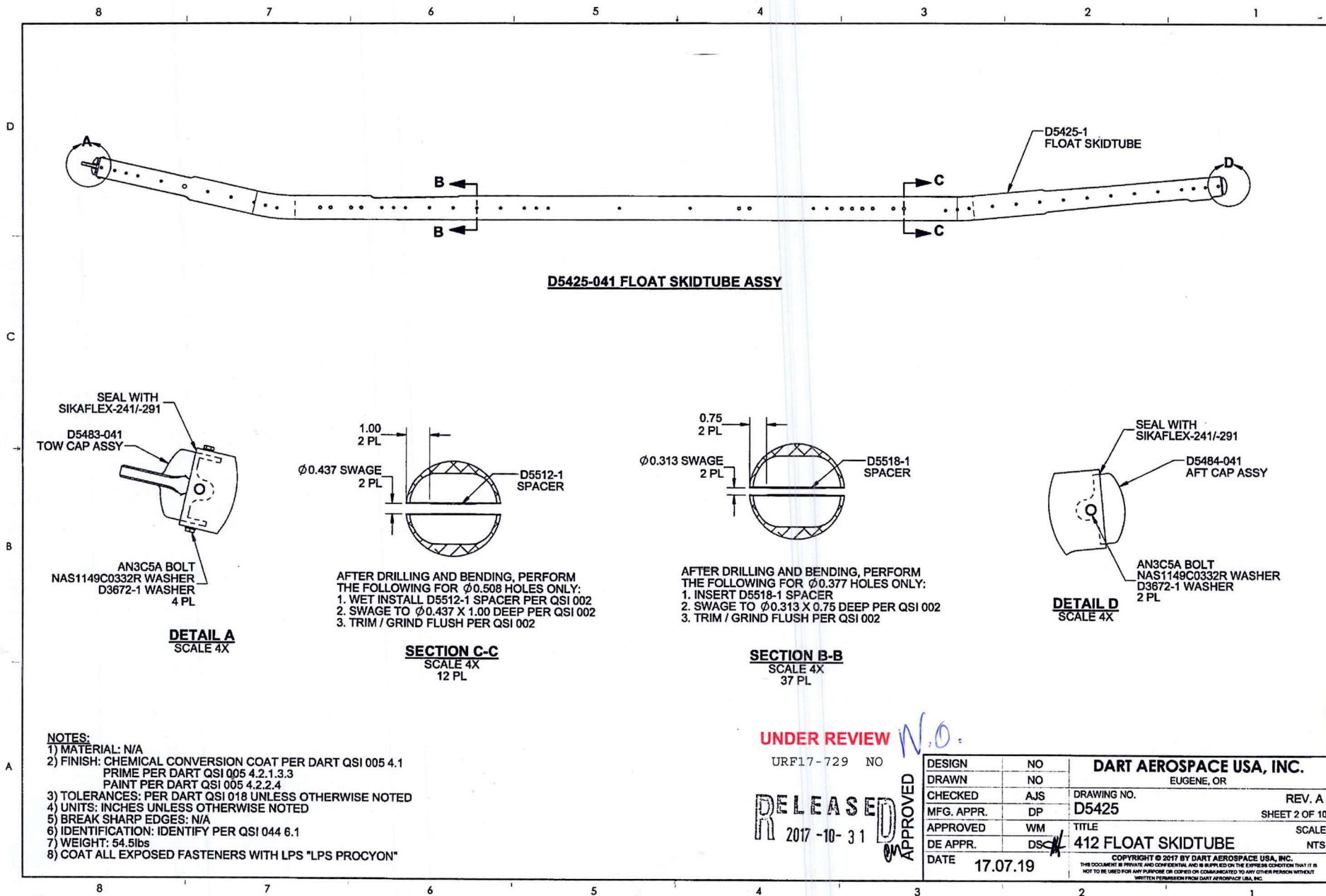
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N.O.

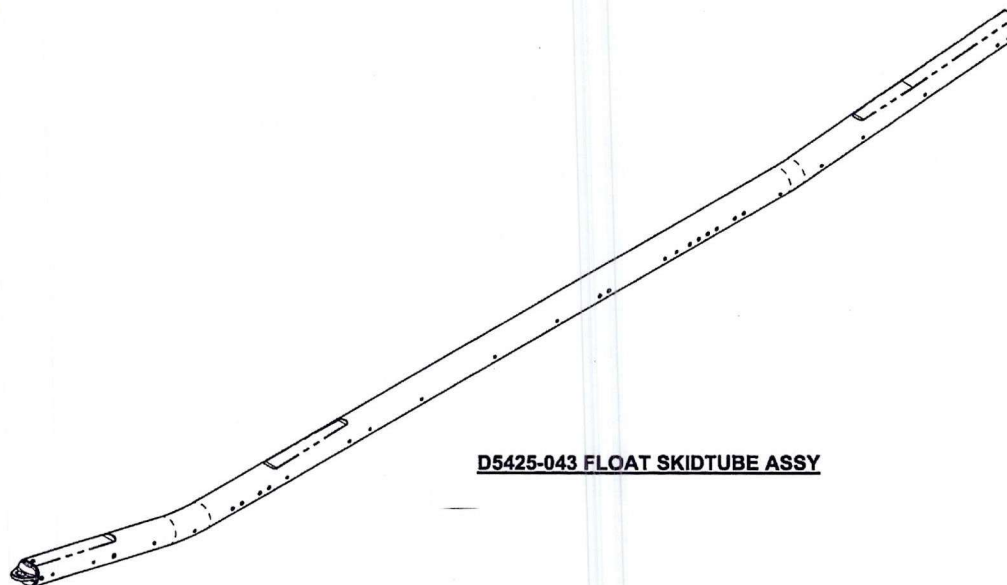
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2017-10-31
ECN 17-728

APPROVED
OM

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DRAWN	NO	EUGENE, OR	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 1 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



D5425-043 FLOAT SKIDTUBE ASSY

UNDER REVIEW *N.O.*

URF17-729 NO

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2017-10-31

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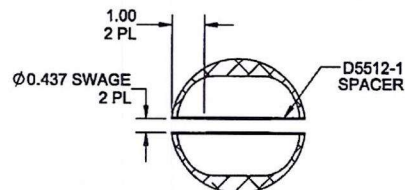
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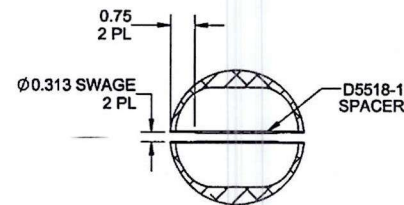


DETAIL E
SCALE 4X



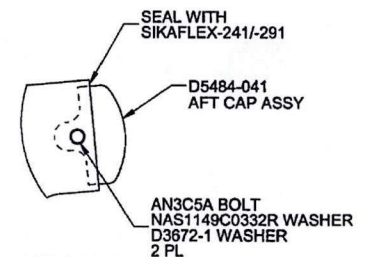
AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION G-G
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM
THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION F-F
SCALE 4X
18 PL



DETAIL H
SCALE 4X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 54.3lbs
- 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

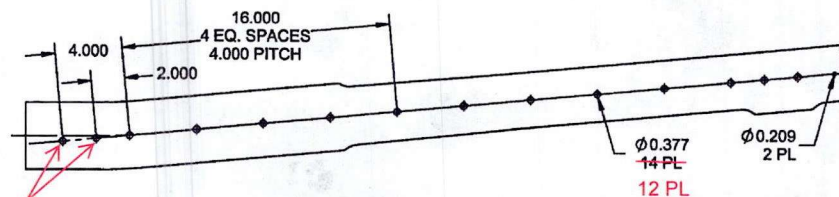
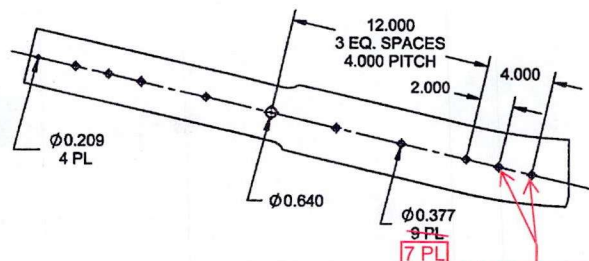
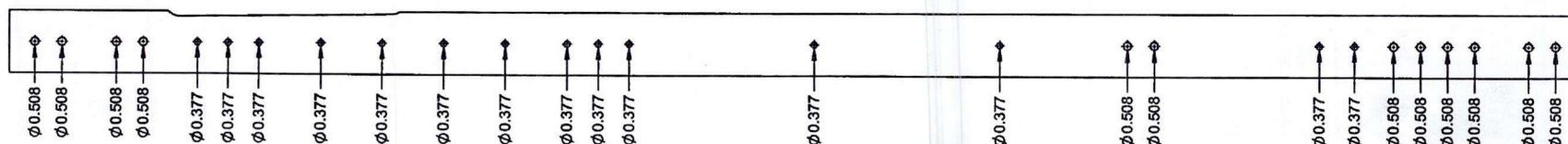
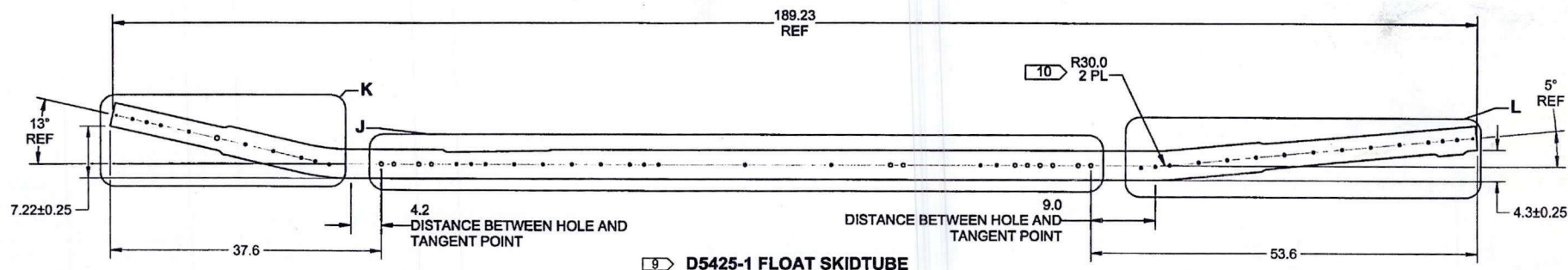
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URF17-729 NO

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NOTES:

- 1) MATERIAL: MAKE FROM D5425-1DRILL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
- 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3" FROM EXTRUSION CENTERLINE AT ANY POINT
- 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

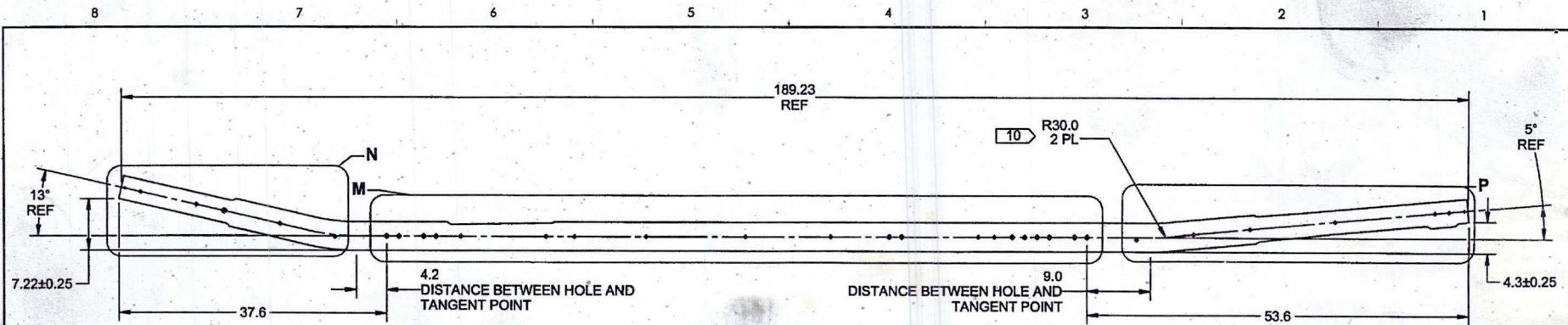
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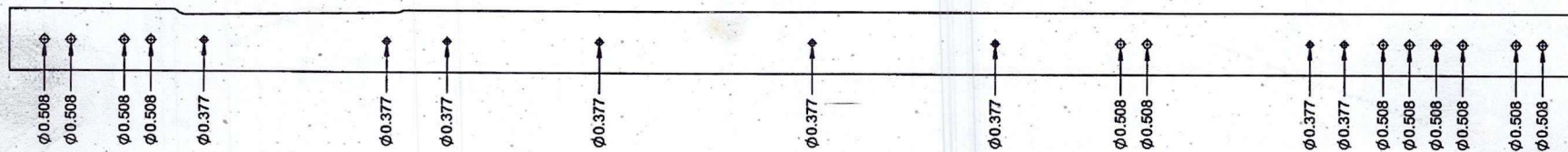
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2017-10-31

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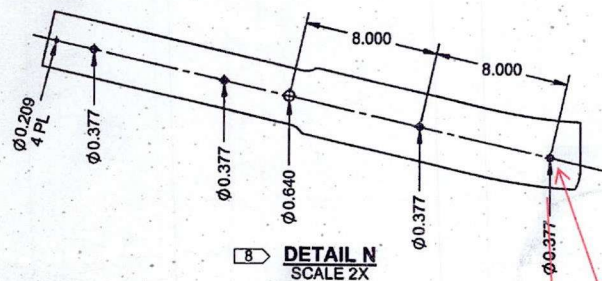
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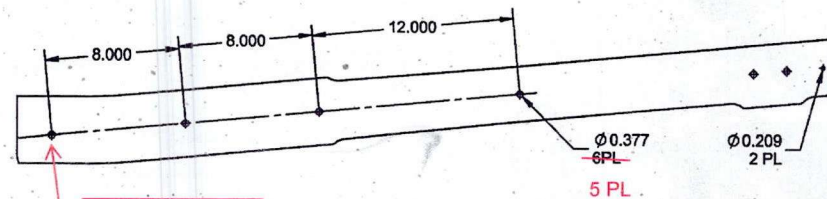
9 D5425-3 FLOAT SKIDTUBE



8 DETAIL M
SCALE 2X



8 DETAIL N
SCALE 2X



8 DETAIL P
SCALE 2X

NOTES:

- 1) MATERIAL: MAKE FROM D5425-3DRILL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) ALL HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
- 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
- 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

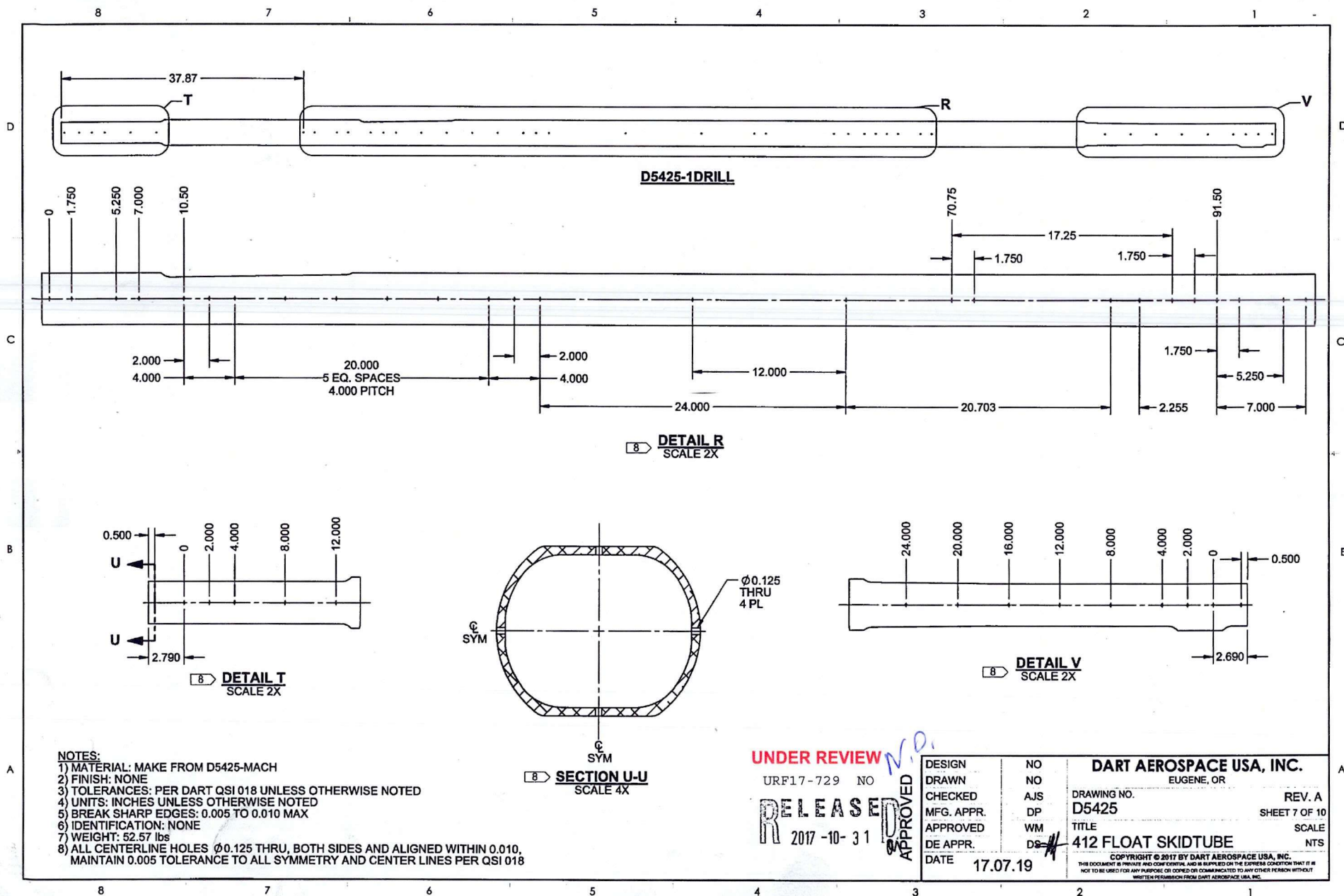
UNDER REVIEW

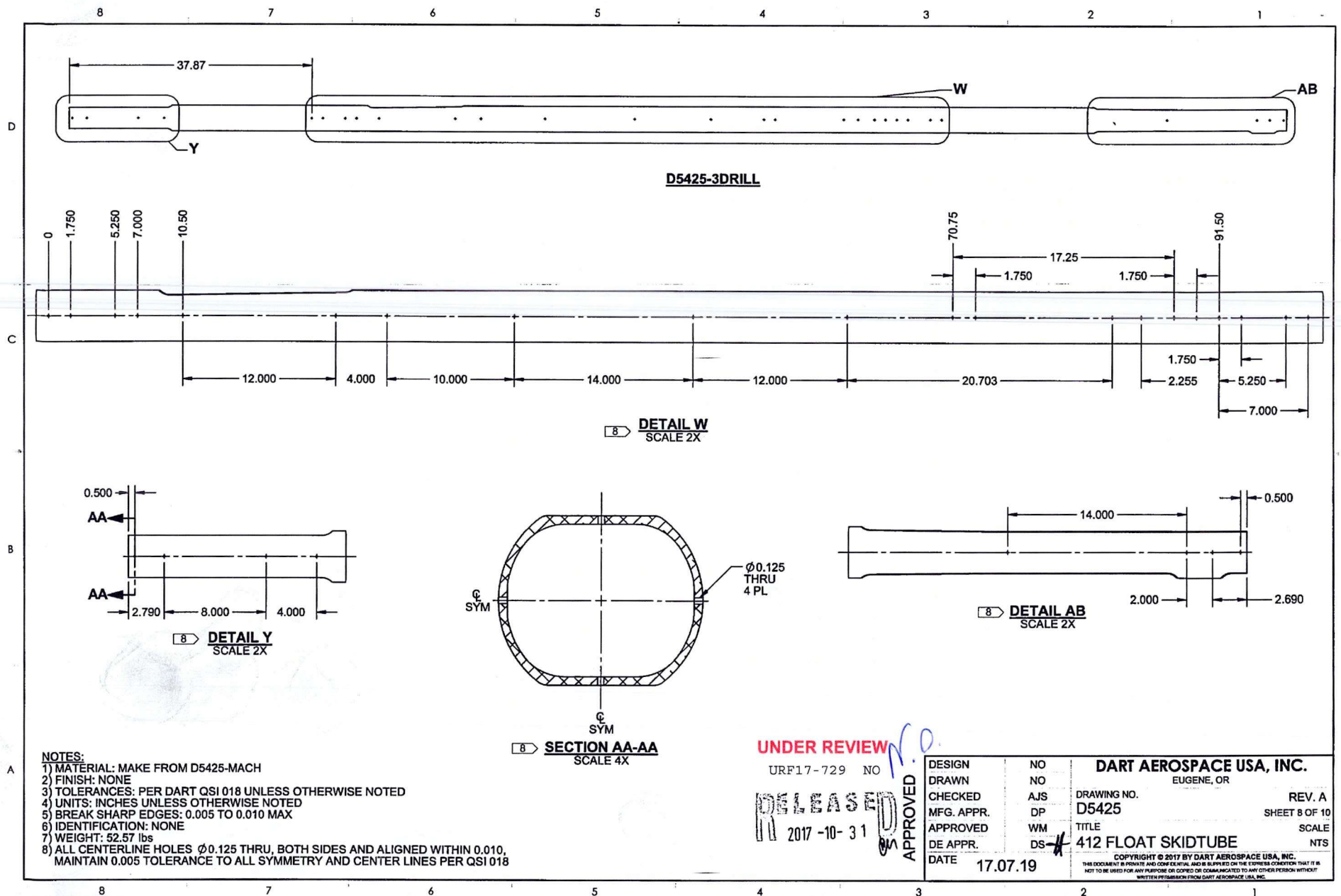
URF17-729 NO

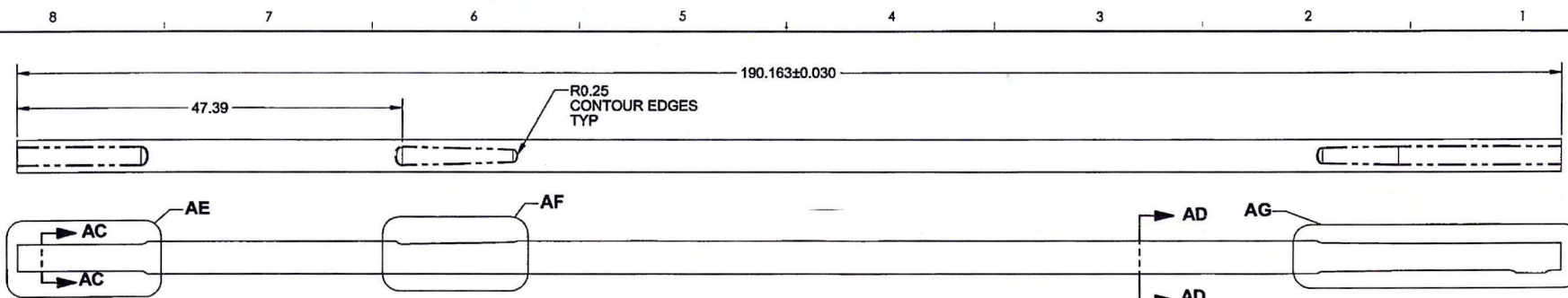
RELEASED
2017-10-31

APPROVED

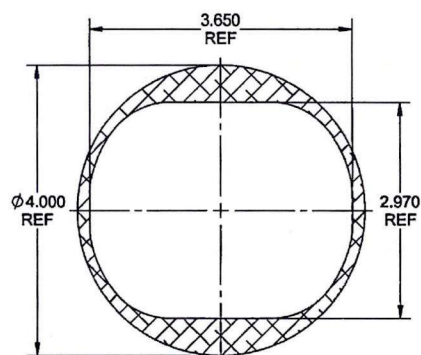
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 6 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
DATE	17.07.19	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



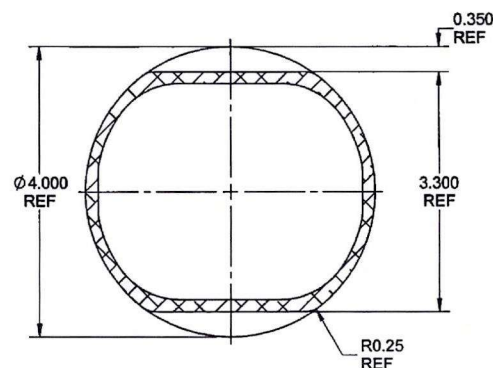




D5425-MACH
MACHINED TUBE



SECTION AD-AD
SCALE 8X



SECTION AC-AC
SCALE 8X

NOTES:

- 1) MATERIAL: MAKE FROM D6028-195 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) NO SHARP CORNERS. MIN RADIUS 0.125"

UNDER REVIEW

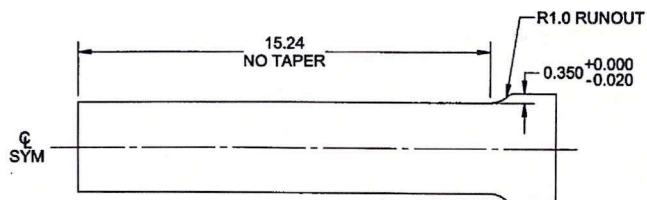
URF17-729 NO

2017-10-31

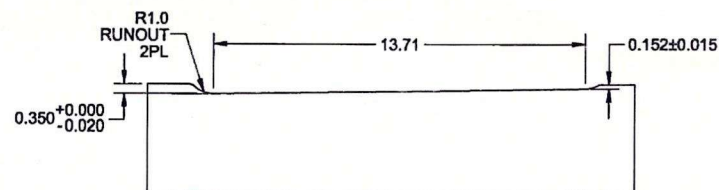
APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 9 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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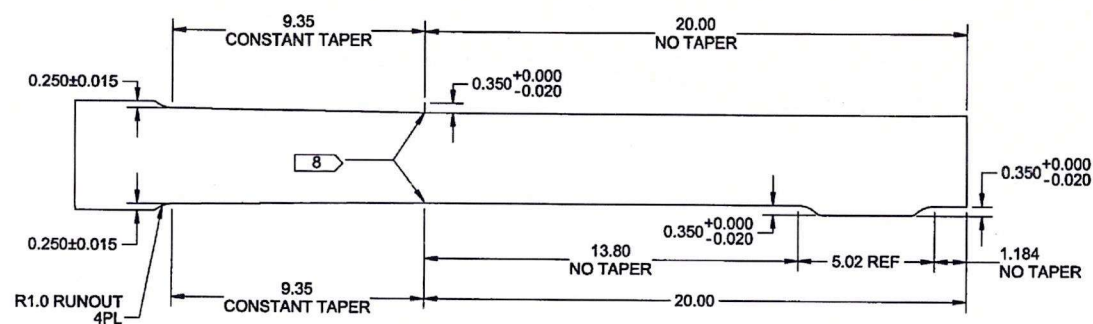
8 7 6 5 4 3 2 1



DETAIL AE
SCALE 3X



DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

UNDER REVIEW

URF17-729 NO

RELEASED
2017-10-31

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DP	D5425	SHEET 10 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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8 7 6 5 4 3 2 1

229
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151

DART AEROSPACE LTD		Work Order:
Description: FLOAT SKIDTUBE		Part Number: D5425-043
Inspection Dwg:	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	±0.010	0.500	✓		Kt-05	verm
2.790	±0.010	2.790	✓		"	"
10.790	±0.010	10.790	✓		CUC-02	verm
14.790	±0.010	14.790	✓		TAPE	—
43.116	±0.010	43.116	✓		↓	↓
44.866	±0.010	44.866	✓			
48.366	±0.010	48.366	✓			
60.366	±0.010	60.366	✓			
64.366	±0.010	64.366	✓			
74.366	±0.010	74.366	✓			
121.069	±0.010	121.069	✓			
123.324	±0.010	123.324	✓			
125.866	±0.010	125.866	✓			
127.616	±0.010	127.616	✓			
129.366	±0.010	129.366	✓			
131.116	±0.010	131.116	✓			
134.616	±0.010	134.616	✓			
136.366	±0.010	136.366	✓			
0.500	±0.010	0.500	✓		Kt-05	verm
2.690	±0.010	2.690	✓		"	"
4.690	±0.010	4.690	✓		"	"
18.690	±0.010	18.690	✓		TAPE	—
15.24	±0.030	15.24	✓		"	"
R1.0	±0.100	1.0	✓		R-G	—
0.350	±0.000	0.348	✓		machine	—
0.350	±0.000	0.349	✓		"	"
R1.0	±0.100	1.0	✓		R-G	—
13.71	±0.030	13.71	✓		TAPE	—
0.152	±0.015	0.140	✓		machine	—
0.250	±0.015	0.242	✓		" "	" "
9.35	±0.030	9.35	✓		TAPE	—
0.350	±0.000	0.348	✓		machine	—

Measured by: 1 Kt	Checked by: <i>mf</i>	QC Inspector:
Date: 9-89 18-01-19	Date: 18/01/22	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☒ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date : _____	Sequence #: <u>190</u>	QTY Affected : <u>1</u>	MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By
Damaged During Manufacturing		Scrap use for tooling		JW 19-05-14
				Lead hand / Supervisor JW 19-05-14
				QC / QA Coordinator DAS 68 9-89 MAY 14 2019
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				